

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016777**Date Inspected:** 15-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr. Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC TESTING

OBG SEGMENT 10BW-10CW

ABF Report No: UT-10W-037

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the edge panel splice weld between OBG segment 10BW and 10CW on the counter weight side. The weld designations were as follows:

OBW10A-001 (OBG 10BW-10CW, EP, CW side)

OBG SEGMENT 10AE

ABF Report No: UT-10E-030R1

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector performed verification Ultrasonic Testing in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the hold back welds between edge panel and deck panel of OBG segment 10AE at intersection of OBG segment 10BE on cross beam side. The weld designations were as follows:

SEG060*-035 (OBG 10AE, DP to EP, C.B side @ 10BE)

OBG SEGMENT 10BE

ABF Report No: UT-10E-030R1

This QA Inspector performed verification Ultrasonic Testing in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the hold back welds between edge panel and deck panel of OBG segment 10BE at intersection of OBG segment 10AE on cross beam side. The weld designations were as follows:

SEG075-002 (OBG 10BE, DP to EP, C.B side @ 10AE)

This QA Inspector randomly observed the following work in progress.

OBG LIFT # 10 WEST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 046067 performing the Shielded Metal Arc Welding process on weld 008 located at PCMK OBW10L. ZPMC QC Mr. Zhong Peng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-u4b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 046709 performing the Shielded Metal Arc Welding process on weld 005 located at PCMK OBW10L. ZPMC QC Mr. Zhong Peng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-u4b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 041713 performing the Shielded Metal Arc Welding process on weld 010 located at PCMK OBW10L. ZPMC QC Mr. Zhong Peng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-u4b-Fcm-1.

This Quality Assurance (QA) Inspector observed ABF personnel performing Ultrasonic Testing on the side panel splice weld between OBG segment 10BW and 10CW on cross beam side.

This Quality Assurance (QA) Inspector observed ABF personnel performing Magnetic Particle Testing on the side panel splice weld between OBG segment 10AW and 10BW on cross beam side.

This Quality Assurance (QA) Inspector observed ABF personnel performing Ultrasonic Testing on the bottom panel splice weld between OBG segment 10BW and 10CW.

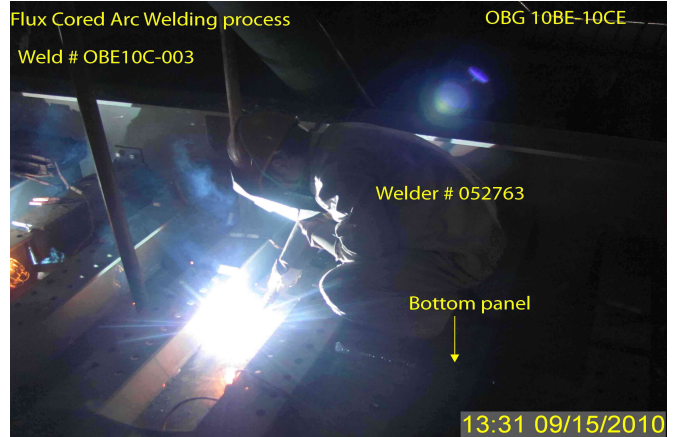
WELDING INSPECTION REPORT

(Continued Page 3 of 3)

OBG SEGMENT 10BE-10CE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 052763 performing the Flux Cored Arc Welding process on weld 003 located at PCMK OBE10C. ZPMC QC Mr. Liu Hue Jie was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2231T.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
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Reviewed By:	Peterson,Art	QA Reviewer
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